DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 82.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-019391
Date Inspected: 13-Jan-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Westmont Industries

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: Santa Fe Springs, CA.

CWI Name: Ruben Dominguez

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: Travelers

Summary of Items Observed:

The Quality Assurance Inspector Sean Vance arrived on site at Westmont Industries (WMI) in Santa Fe Springs, CA, to randomly observe the in process welding, QC inspection and non-destructive testing of the Travelers. Upon the arrival of the QA Inspector, the following observations were made:

Traveler Test Rack

On this date, the QA Inspector randomly observed WMI production personnel performing fitting, welding and cutting activities on various assemblies for the Traveler Test Rack.

SAS-EB Traveler

On this date, the QA Inspector observed 2 WMI Production personnel continuing to perform fitting activities on the previously completed sections of the SAS-EB Traveler. The QA Inspector observed that the sections had been previously relocated to the outside fabrication Bay # 6 and the sections appeared to be identified as the Elevated Truss, Fixed Stairs and Lower Truss Sections. During observation, the QA Inspector observed that various come alongs and chain falls were being utilized, during the fit-up process.
Near the end of the shift, the QA Inspector observed that the fit-up on the above mentioned three sections, appeared to still be in process, at this time.

E2/E3-EB Traveler

On this date, the QA Inspector observed WMI production welder Mr. Juan Jimenez (WID # 3059) continuing to perform Flux Core Arc Welding (FCAW) welding activities on the frame assembly identified as 7-A327, per the shop drawings.

The QA Inspector observed throughout the shift, that the FCAW was being performed in various positions, on the connector plate and Tube Steel (TS) material fillet and flare groove welds.
Additionally, the QA Inspector observed WMI production welder Mr. Eutimo Lopez (WID # 3035) performing FCAW welding activities on the above mentioned frame assembly. The QA Inspector observed Mr. Lopez performing the FCAW in various positions, on the connector plate and Tube Steel (TS) material fillet and flare groove welds.
Additionally, the QA Inspector observed WMI production welder Mr. Cesar Canales (WID # 3195) performing fitting and FCAW tacking activities on the above mentioned frame assembly. The QA Inspector observed that the activities were being performed on the intermediate and diagonal tube steel connector plate material.

On this date, the QA Inspector observed WMI production welders Mr. Jesus Rayas (WID # 3197 and Mr. Charles Newton (WID # 3200) performing fitting and FCAW tacking and welding activities on the assembly identified as 95 A364C, Elevating Platform. The QA Inspector observed that these activities were being performed on the hand rail tube steel material and continued throughout the shift.

On this date, the QA Inspector observed WMI production welders Mr. Charles Newton (WID # 3200) and Mr. Richard Fuentes (WID # 3201) performing fitting and flux core arc welding on tube steel material for the frame assembly identified as 3 A317-1. During observation, the QA Inspector observed that the above mentioned personnel appeared to be splicing additional TS material, to this previously fabricated assembly. During observation, the QA Inspector observed that the joint preparation appeared to be a single bevel, Complete Joint Preparation (CJP) with backing and approximately 3 mm root opening.
In regards to these activities, the QA Inspector had been previously informed that these splices are required to lengthen the bottom section TS material to achieve proper fit up between the frame assemblies A332 and B332. The QA Inspector had been previously informed that the bottom section piece of TS material had been previously cut to length according to the Shop Drawing Bill of Material List.
The QA Inspector noted that the above mentioned activities are being performed, prior to WMI submitting a Request for Information (RFI).
See Summary of Conversations below.

On this date, the QA Inspector observed SE QC Inspector Ruben Dominguez performing what appeared to be random Magnetic Particle Testing (MT) on the assemblies identified as 95 A364C, Elevating Platform and frame 8 B27, for the E2/E3-EB Traveler. The QA Inspector observed that the testing was being performed on the previously completed fillet and flare groove welds.
During observation, the QA Inspector then spoke with QC Inspector Dominguez and Mr. Dominguez explained that he was performing the testing, in accordance to the approved MT Procedure SE-MT-CT.D1.1-105, Rev. # 1 and the testing is currently being performed at random locations, on approximately 10 % of the completed welds. Mr. Dominguez further explained that he had previously performed Visual Testing on the welds and the welds were acceptable, per AWS D1.1 2002 Visual Acceptance Criteria.
The QA Inspector was later informed by QC Inspector Dominguez that no rejectable indications were found after testing and that an applicable Magnetic Testing report will be completed, per the contract requirements.

The QA Inspector randomly observed that Smith-Emery QC Inspector Ruben Dominguez was present, during the above mentioned welding and fitting activities.
During random observation, the QA Inspector observed that the applicable WPS’s and copies of the shop drawings,

appeared to be located near each work station, where the above mentioned welding and fitting activities were being performed.

The QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS and that the above mentioned welders were currently qualified for the applicable process and position of welding.

The QA Inspector randomly observed QC Inspector Dominguez verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the applicable WPS.

Summary of Conversations:

The QA Inspector spoke with WMI representative Brad Petrie in regards to the additional TS splices. Mr. Petrie explained that an RFI will be generated, to address this issue.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Vance,Sean	Quality Assurance Inspector
Reviewed By:	Edmondson,Fred	QA Reviewer